

Date: Thursday, 20/11/2008 3:35:14 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 43620	
Estimate Number : 11144	
P.O. Number :	Part Number : D32075
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3207 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39701	Material :
Written By :	Due Date : 21/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUP 08.11.21</u>	
Comment : Est A 04.06.09 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0773 sf(s)/Unit Total : 0.3091 sf(s)

6061-T6 .125 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.125" thick

(M6061T6S.125)

Identify for D3207-5

Batch: 109058HB 8-12-11

(6)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3207

Dwg Rev: AProg Rev: AHB 8-12-11

2-Deburr if necessary

HB 8-12-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-12-11**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK808/12/11 (6)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Form as per Dwg D3207

808/12/11

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43620

Part Number: D32075

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/12/16 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/17

8.0

POWDER COATING

POWDER COATING



M 109648



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:20
320 OF
1:50

MF 08/12/18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FL 08/12/18 (6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 200

8/12/18

6x

50

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



MF 08-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

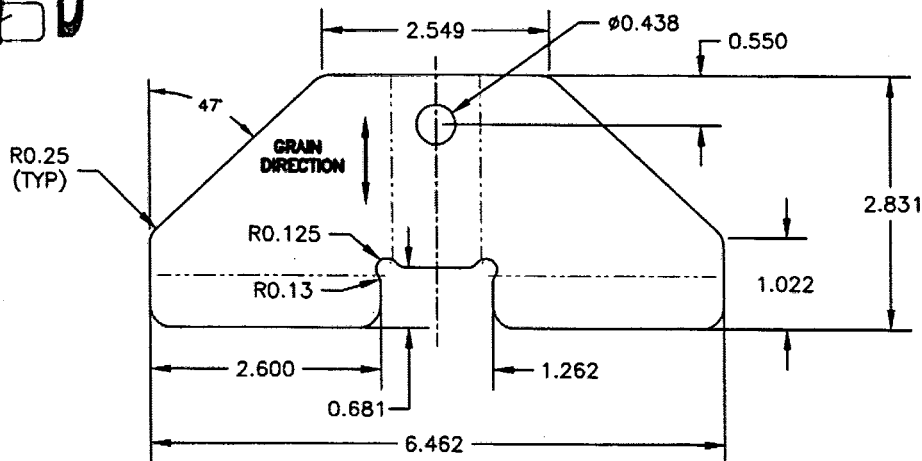
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

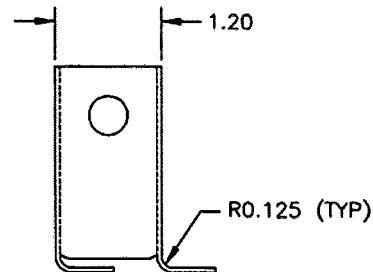
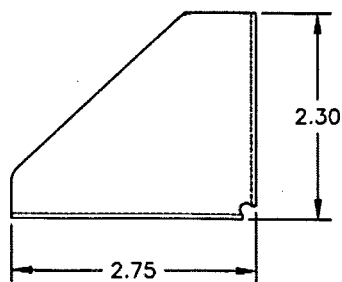
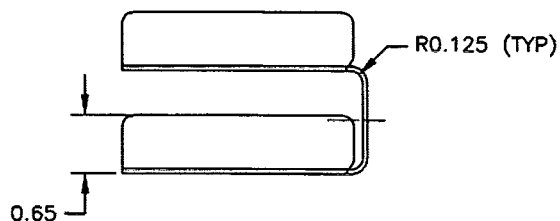


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN



**D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE**

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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WITHOUT NOTICE
WORK ORDER
NO. *43620*

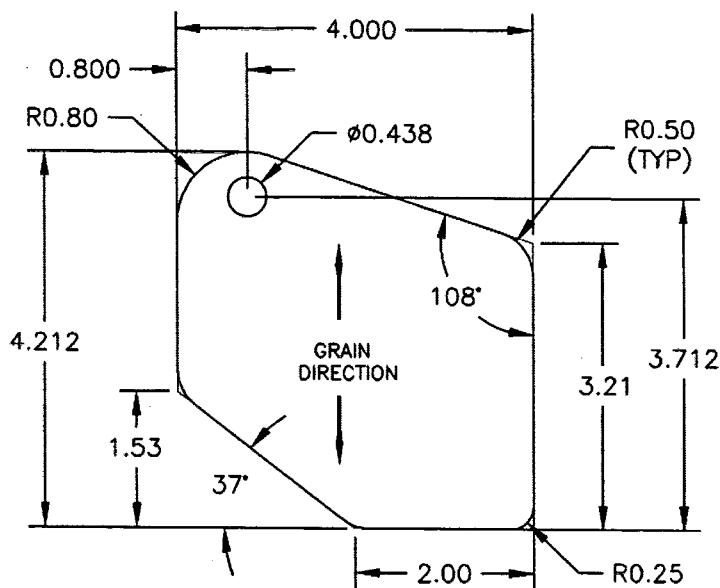
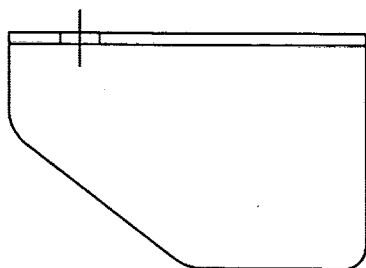
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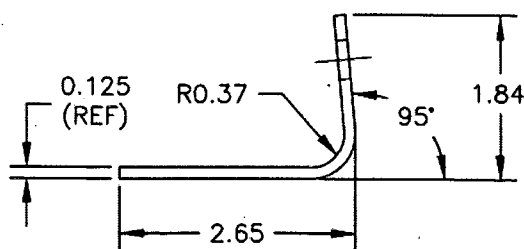
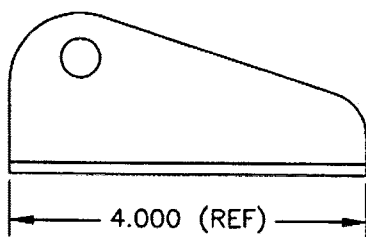


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CHECKED JH	APPROVED JH	DRAWING NO. D3207	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED
04.04.05



D3207-3 FLAT PATTERN



D3207-3 BEND DETAIL

D3207-3 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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NO. 43620

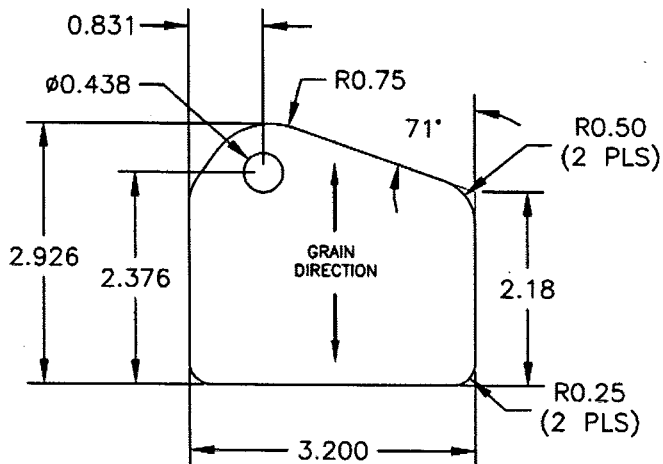
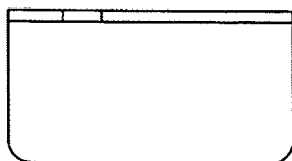
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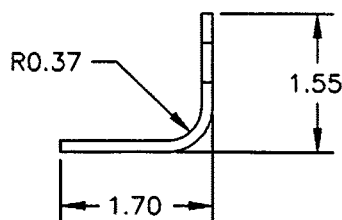
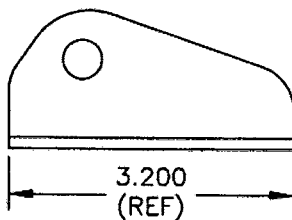


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

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04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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